

Work Order ID 81686

Friday, March 16, 2012 1:56:17 PM

81686

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Item ID: D3782-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Back Leg Assembly

Start Date: 3/29/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/29/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date: 3-23-12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3782

Rev B

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

Small Fab

0.00

110

Small Fab

Memo

0.00

Small Fab

1-assemble as per dwg D3782

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

SB 12/05/10

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Item ID: D3782-045
 Revision ID:
 Item Name: Back Leg Assembly
 Start Date: 3/29/2012 Start Qty: 6.00
 Required Date: 3/29/2012 Req'd Qty: 6.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/
 Work Center ID

Operation
 Description

Set Up/
 Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
 Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: **GA**

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

①

12/5/10

12/5/10

UNF
 12-05-10

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D3782-045

Required Date: 3/29/2012

Required Qty: 6.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C
10.02.22 revB as per dwg DD verified by:EC

D3772-1	Manufactured	No.	110	Each	2.0000	1	6	
D3772-1						**	6	(4) FF 12-05-10
Back Leg								

D3787-1	Manufactured	No	110	Each	12.0000	1	6
D3787-1					**		
Foot							

(6) FF 12-05-10

D3764-1	Manufactured	No	110	Each	1.0000	1	6
					**		
						DFF 12-05-10	

D3773-041	Manufactured	No	110	Each	0.0000	1	6	
D3773-041							6	
Headrest Assembly						**	6	(4) FF 12-05-10

D3786-1	Manufactured	No	110	Each	0.0000	1	6	<i>FF 12-05-10</i>
D3786-1						**		
Sleeve								

Picklist Print

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Work Order ID: 81686

81686

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 6.00

Required Qty: 6.00

AN45-15A

Purchased

No

110

Each

12.0000

1

6

AN45-15A

EYE BOLT

**

④ FF 12-05-10

Location

Loc Qty

Loc Code

ST362

12

114523

2

115908

10

AN5-15A

Purchased

No

110

Each

99.0000

1

6

AN5-15A

Bolt

**

④ FF 12-05-10

Location

Loc Qty

Loc Code

ST338

99

115159

49

115316

50

AN5-17A

Purchased

No

110

Each

80.0000

1

6

AN5-17A

Bolt

**

④ FF 12-05-10

Location

Loc Qty

Loc Code

ST338

80

117872

42

120498

38

AN4-15A

Purchased

No

110

Each

367.0000

2

12

AN4-15A

Bolt

**

④ FF 12-05-10

Location

Loc Qty

Loc Code

GA

100

120449

100

ST358

267

118706

15

120187

52

120422

200

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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 81686

81686

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 6.00

Required Qty: 6.00

MS21042L4

Purchased

No

110

Each

5,519.000

2

12

MS21042L 4

**

Nut

① FF 12-05-10

Location

Loc Qty

Loc Code

ST300

5519

117441

51

117601

157

118451

133

119017

200

119075

2978

121011

2000

12

MS21042L5

Purchased

No

110

Each

1,598.000

3

18

MS21042L 5

**

Nut

① FF 12-05-10

Location

Loc Qty

Loc Code

ST300

1598

116105

5

116548

43

117611

42

118179

8

119109

1500

18

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

14.0000

4

24

AN960.JD416

**

Washer

① FF 12-05-10

Location

Loc Qty

Loc Code

ST351

14

116289

14

116289

14

14

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

5

30

AN960.JD516

**

Washer

① FF 12-05-10

116289

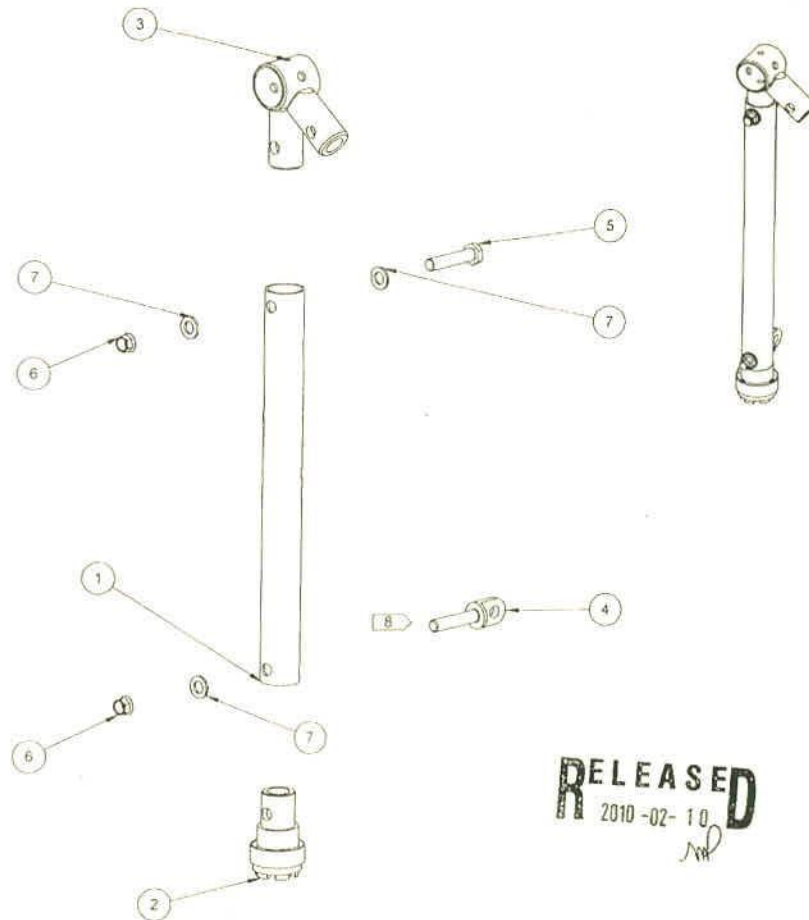
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Shop Packet Print

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ITEM NO.	QTY. (-041)	PART NUMBER	DESCRIPTION
1	1	D3768-1	FRONT INBOARD LEG
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	1	AN45-13A	EYE BOLT
5	1	AN5-13A	BOLT
6	2	MS21042L5	NUT
7	3	NAS1149D0563J	WASHER (AN960JD516)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *87686*



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2010-02-10
NTS

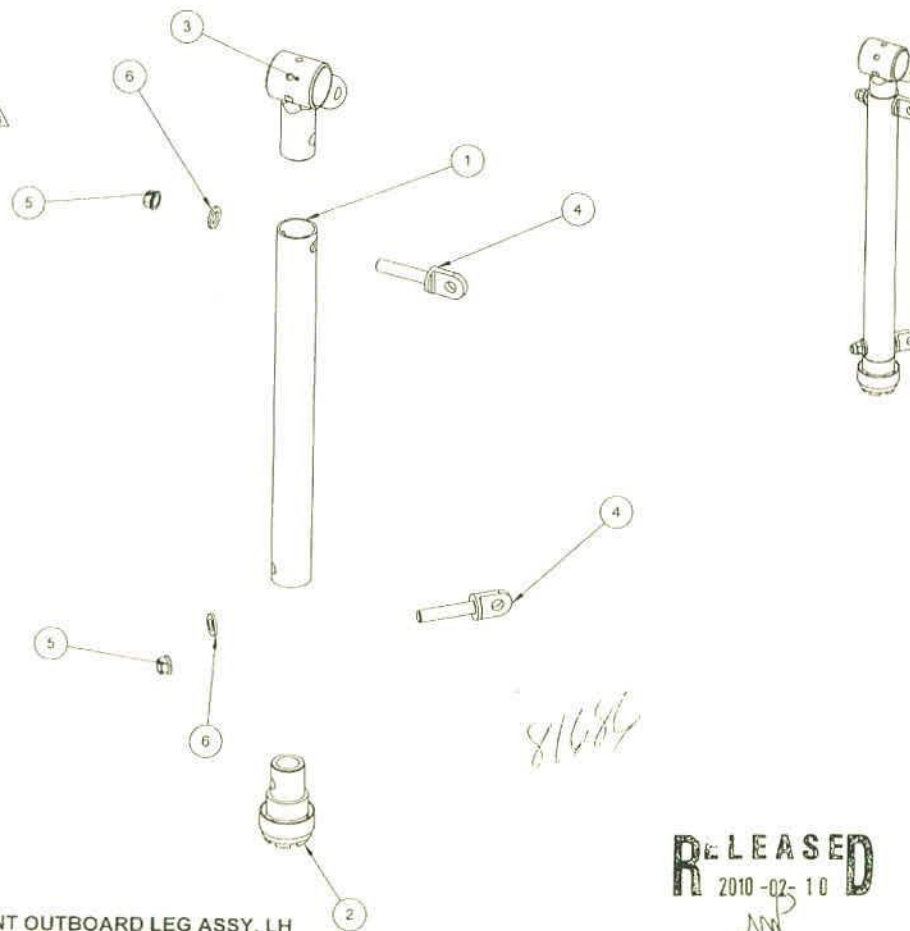
D3782-041 FRONT INBOARD LEG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 4 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

B	REVISE P/N NAS1149D0563J TO NAS1149D0563J ALL SHEETS, ZN D7	HS	10.01.21
A	NEW ISSUE	BY	DATE
REV	DESCRIPTION	BY	DATE
DESIGN	<i>HS</i>	DART AEROSPACE LTD	
DRAWN	<i>HS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>HS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>HS</i>	D3782	SHEET 1 OF 4
APPROVED	<i>HS</i>	TITLE	SCALE
DE APPR.	<i>HS</i>	LEG ASSEMBLY	NTS
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ITEM NO.	QTY (-043)	PART NUMBER	DESCRIPTION
1	1	D3768-3	FRONT OUTBOARD LEG, LH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



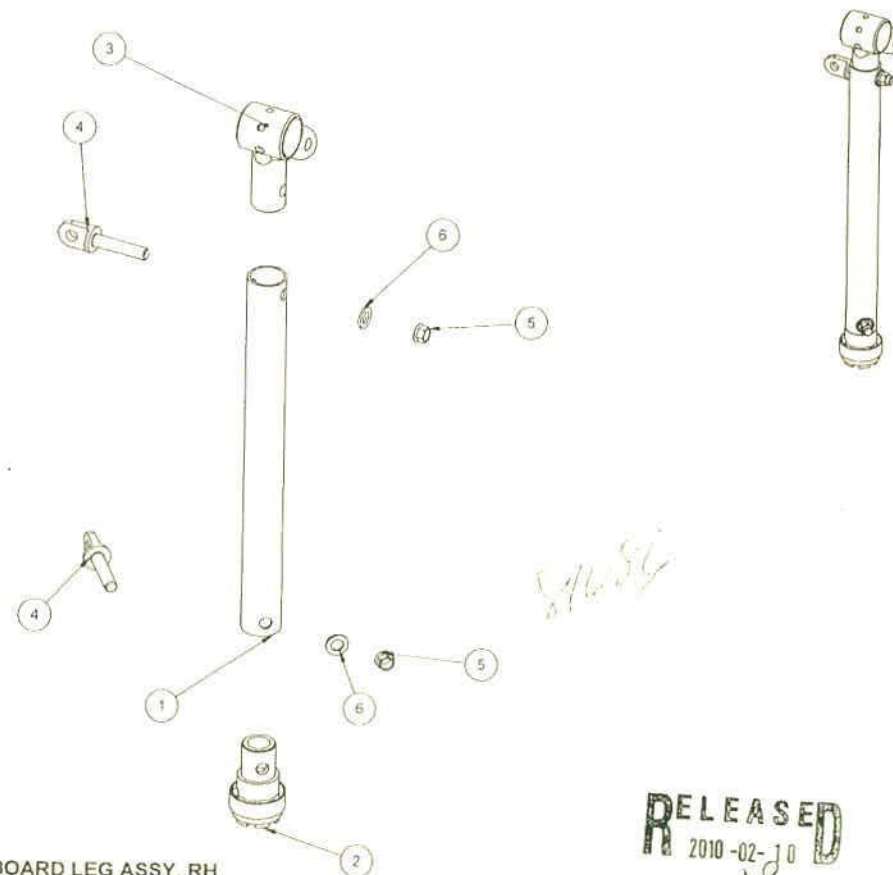
D3782-043 FRONT OUTBOARD LEG ASSY, LH

RELEASED
2010-02-10
MM

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs

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CHECKED	451	DRAWING NO.	REV. B
MFG APPR	451	D3782	SHEET 2 OF 4
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DE APPR	451	LEG ASSEMBLY	NTS
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ITEM NO	QTY. (-044)	PART NUMBER	DESCRIPTION
1	1	D3768-4	FRONT OUTBOARD LEG, RH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



D3782-044 FRONT OUTBOARD LEG ASSY, RH

RELEASED
2010-02-10

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

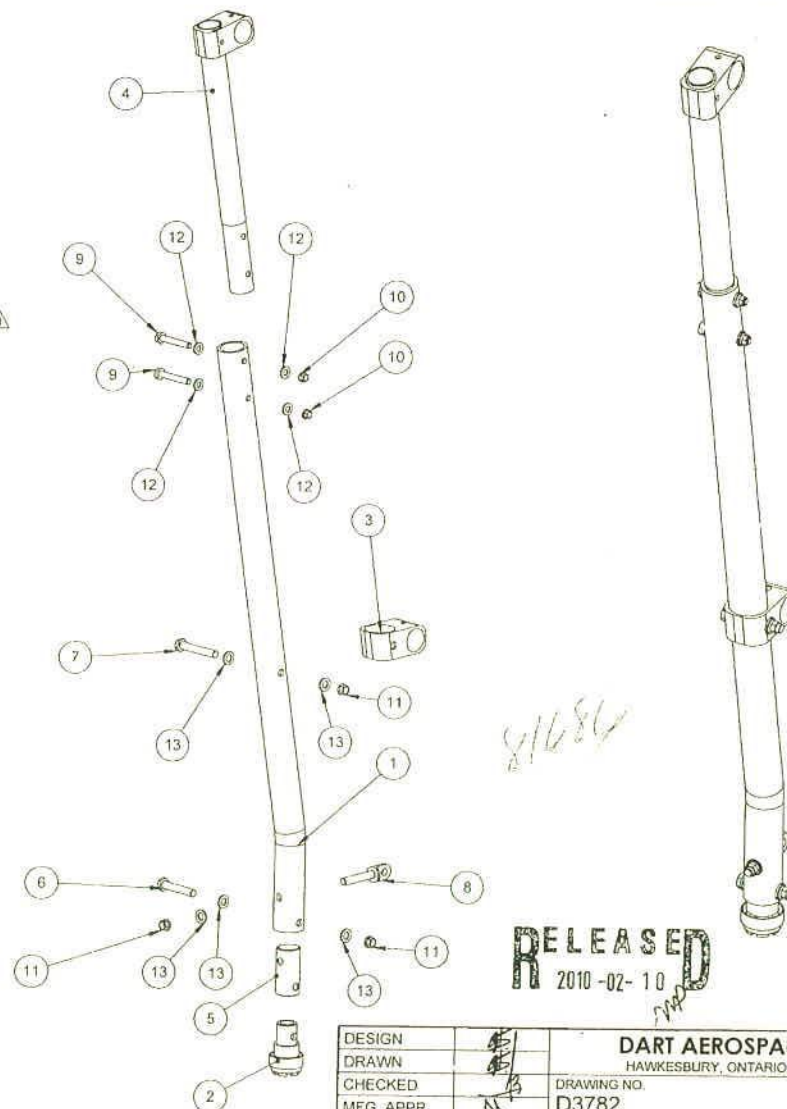
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ITEM NO.	QTY. (-045)	PART NUMBER	DESCRIPTION
1	1	D3772-1	BACK LEG
2	1	D3787-1	FOOT
3	1	D3784-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0463J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)

D3782-045 BACK LEG ASSY

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs



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